

5

DART AEROSPACE LTD	Work Order:	18783
Description: Mounting Lug/Nut Plate Kit	Part Number:	K10017
Dwg: D3175 Rev. A; D3178 Rev. A	Qty:	4
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Minimum of one batch per 2 set of Aircraft <i>Steps 8</i>	<i>HA</i>	03.01.29	4
2	MV	Cut blanks: 3.00" x 1.520" Material: 5052-H32/H34 sheet (QQ-A-250/8) 0.063" thick (M5052H32S.063) <i>(2 per K10017)</i> (Cut 1 stack per batch) <i>Stack of 8</i> Identify as D3178-1 <i>Batch: M12824</i>	<i>SB</i>	03.01.29	4
3	MV	Cut blanks: 2.5" x 1.5" x 2.2" (grain along 2.2") Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) (M6061T6B1.500x02.500) <i>(4 per K10017)</i> (Cut 16 blanks per batch) Identify as D3175-1 <i>Batch: M10974</i> (Note: (2) D3175-1 are required per D3175-041 assembly)	<i>SD</i>	03.01.29	4
4	MV	Cut blanks: 2.125" x 1.250" Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) 0.375" thick (M6061T6B0.375x01.250) <i>(2 per K10017)</i> (Cut 8 blanks per batch) Identify as D3175-3 <i>Batch: M7321</i>	<i>SB</i>	03.01.29	4
5	MV	Machine D3178-1 as per Folio FA296 and Dwg D3178	<i>EC</i>	03.01.30	4
6	QC2	Inspect parts as they come off the CNC machine	<i>EC</i>	03.01.30	4
7	QC8	Second inspection	<i>SPB/B</i>	03.01.30	4
8	MV	Machine D3175-1 as per Folio FA293 and Dwg D3175	<i>EC</i>	03.01.30	4
9	QC2	Inspect parts as they come off the CNC machine	<i>EC</i>	03.01.30	4
10	MV	Deburr and Tumble	<i>EC</i>	03.01.30	4
11	QC8	Second inspection	<i>SP</i>	03.01.30	4
12	MV	Machine D3175-3 as per Folio FA294 and Dwg D3175	<i>EC</i>	03.01.30	4
13	QC2	Inspect parts as they come off the CNC machine	<i>EC</i>	03.01.30	4
14	MV	Deburr and Tumble	<i>EC</i>	03.01.30	4
15	QC8	Second inspection	<i>SP</i>	03.01.30	4
16	GA	C'sink D3178-1 holes as per Dwg D3178	<i>DD</i>	03.02.03	4
17	GA	Deburr stack of D3178-1	<i>AD</i>	03.02.03	4
18	QC5	Inspect C'sink	<i>SP</i>	03.02.03	4
19	FP	Chemical Conversion Coat D3178-1, D3175-1 & D3175-3 per QSI 005 4.1	<i>DD</i>	03.02.03	4
20	QC3	Inspect Conversion Coat	<i>SP</i>	03.02.03	4

RELEASED
03.01.29 RF

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	18783
Description: Mounting Lug/Nut Plate Kit	Part Number:	K10017
Dwg: D3175 Rev. A; D3178 Rev. A	Qty:	1
		Page 2 of 2

Step	Location	Procedure	By	Date	Qty																
21	GA	Assemble D3178-041 as per Dwg D3178 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>64</td><td>MS20426AD3-4</td><td>Rivet</td><td>117690</td></tr><tr><td>32</td><td>MS21059L3</td><td>Nut Plate</td><td>112240</td></tr></table> Identify as D3178-041	Qty	Part Number	Description	Batch	64	MS20426AD3-4	Rivet	117690	32	MS21059L3	Nut Plate	112240	MA	03.02.03	4				
Qty	Part Number	Description	Batch																		
64	MS20426AD3-4	Rivet	117690																		
32	MS21059L3	Nut Plate	112240																		
22	QC5	Inspect D3178-041 Assembly	MA	03.02.03	4																
23	GA	Assemble D3175-041 as per Dwg D3175 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>18</td><td>AN3-7A</td><td>Bolt</td><td>115288</td></tr><tr><td>32</td><td>AN960JD10L</td><td>Washer</td><td>111670</td></tr><tr><td>18</td><td>MS21042L3</td><td>Nut (or -3)</td><td>112206</td></tr></table> Identify as D3175-041	Qty	Part Number	Description	Batch	18	AN3-7A	Bolt	115288	32	AN960JD10L	Washer	111670	18	MS21042L3	Nut (or -3)	112206	MA	03.02.03	4
Qty	Part Number	Description	Batch																		
18	AN3-7A	Bolt	115288																		
32	AN960JD10L	Washer	111670																		
18	MS21042L3	Nut (or -3)	112206																		
24	QC5	Inspect D3175-041 Assembly	MA	03.02.03	4																
25	FP	Powder Coat D3175-041 Only Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	MA	03.02.04	4																
26	QC3	Inspect Powder Coat	MA	03.02.04	4																
27	PK	Identify and Stock as K10017 One set of K10017 includes: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th></tr><tr><td>2</td><td>D3175-041</td><td>Mounting Lug</td></tr><tr><td>2</td><td>D3178-041</td><td>Nut Plate</td></tr></table>	Qty	Part Number	Description	2	D3175-041	Mounting Lug	2	D3178-041	Nut Plate	MA	03.02.21	4							
Qty	Part Number	Description																			
2	D3175-041	Mounting Lug																			
2	D3178-041	Nut Plate																			
28	AC	Cost / part 204.90 11.35	MA	03.02.21	4																
29	DC	Close W/O 204.90 59.74 Inspect Level 21	MA	03.02.21	-																

Rev	Date	Change	Revised By	Approved
A	03.01.28	New issue	KJ/RF	RF

RELEASED
03.01.29 RF

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#:_____ Fault Category:_____ DQA:_____ Date:_____

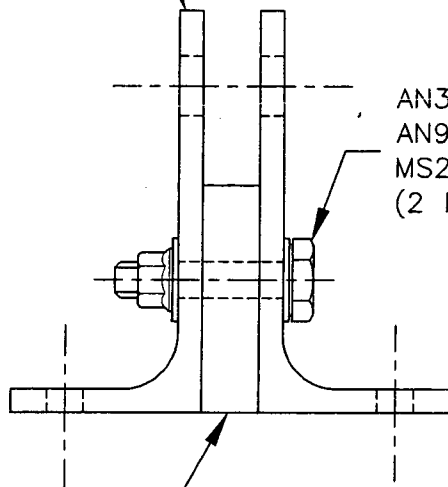
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QA: N/C Closed:_____ Date:_____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3175	REV. A SHEET 1 OF 2
DATE 02.12.03		TITLE MOUNTING LUG	SCALE 1:1
A	02.12.03	NEW ISSUE	

D3175-1
(2 PLACES)

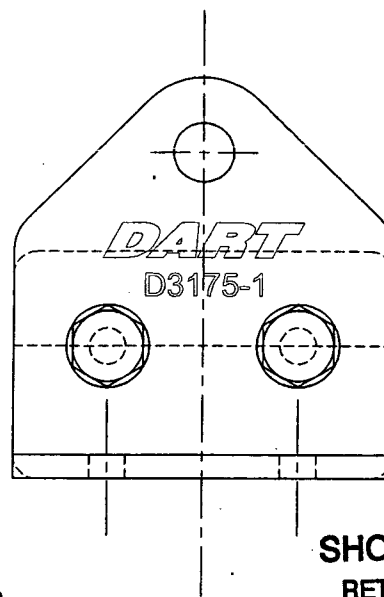


AN3-7A BOLT (1)
AN960JD10L WASHER (2)
MS21042L3 NUT (1)
(2 PLACES)

D3175-3

D3175-041 MOUNTING LUG

FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1)
PER DART QSI 005 4.3

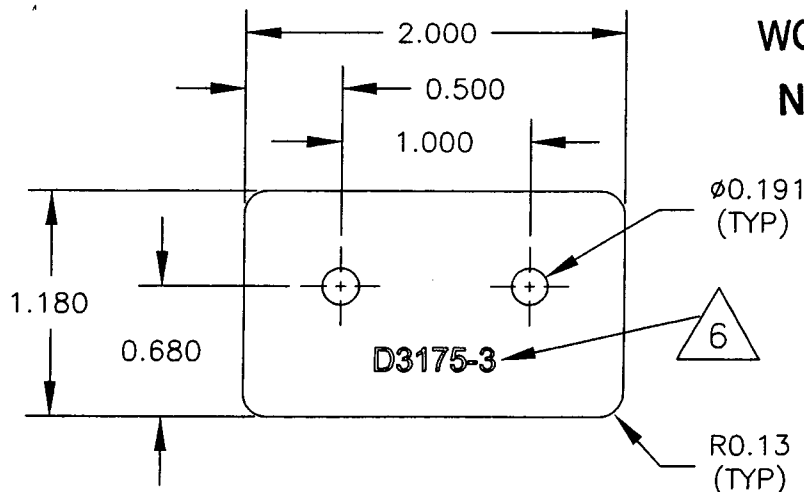


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WORK ORDER
NO. 18783

RELEASED
02.12.03 *#*



D3175-3 SPACER

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.285 TO 0.290 THICK
(QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

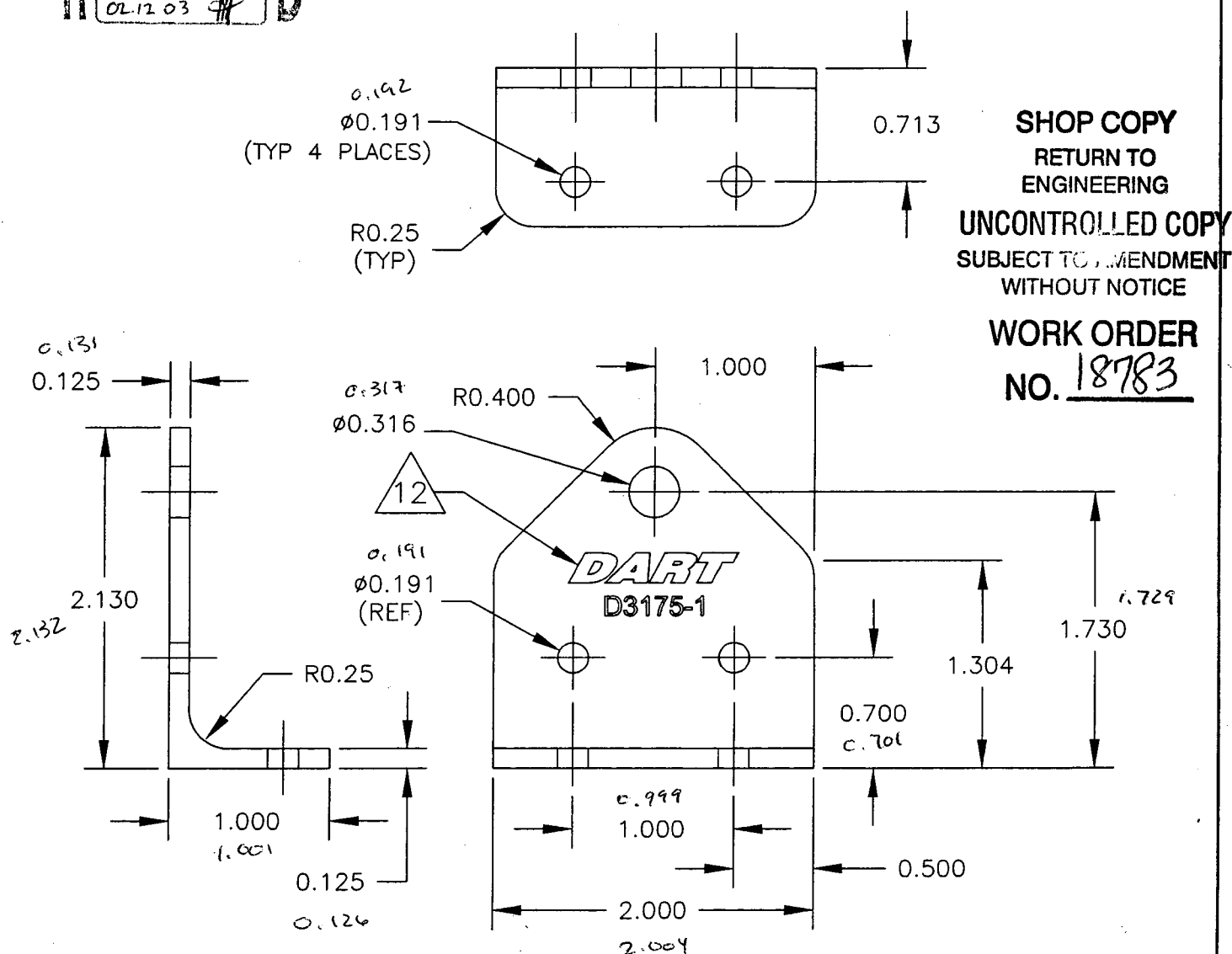
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3175	REV. A SHEET 2 OF 2
DATE 02.12.03		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
02.12.03 *#*



D3175-1 BRACKET

- 7) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 9) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) ENGRAVE DART LOGO & P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

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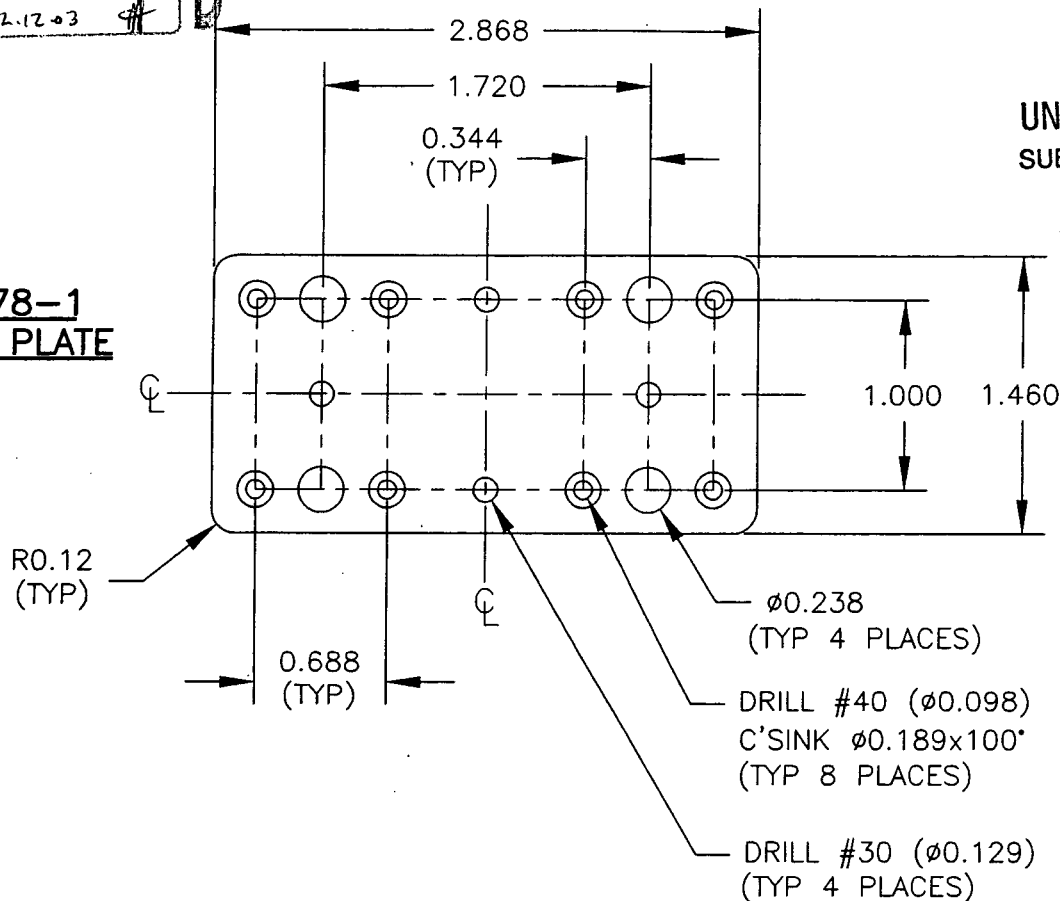
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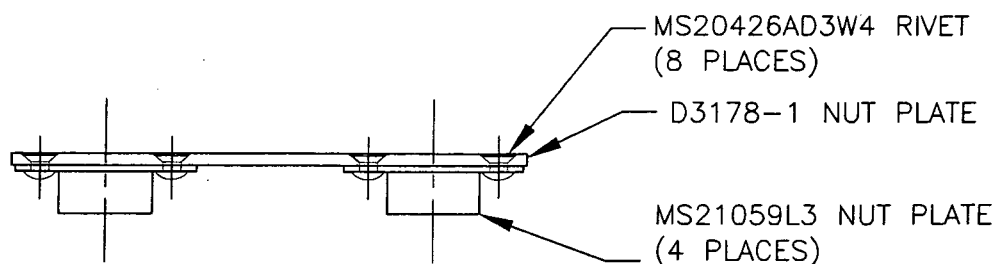
DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3178	REV. A SHEET 1 OF 1
DATE 02.12.03		TITLE NUT PLATE	SCALE 1:1
A	02.12.03	NEW ISSUE	

RELEASED
02.12.03

**D3178-1
NUT PLATE**



**D3178-041
NUT PLATE**



NOTES, D3178-1 NUT PLATE:

- 1) PART IS SYMMETRIC ABOUT CENTERLINES
- 2) MATERIAL: 5052-H32/H34 SHEET 0.063 THICK (QQ-A-250/8)
(REF DART SPEC. M5052H32S.063)
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 18783

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 29, 2003
10:04 am

Work Order No : 0018783
Project Name : *K10017
Project For : WK305
Work Order Type : Main
Main WO Number :
House Part Number : *K10017
Description : Mtg Lug/Nut Plate Kit
Manufactured : Yes
Amount Req'd : 1
Amount Done : 0
Start Date : 01-29-03
Est Finish Date : 01-31-03
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00		
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00		
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Dart Aerospace, Ltd

1270 Aberdeen Street

Hawksbury, Ontario

K6A 1K7

Tel: (613) 632-3336 Fax: (613) 632-4443

Supplier Code: _____ Sheet _____ of _____

INSPECTION CHECKLIST

PART NO.: D3175-1

PHY. CHANGE: *N/A*

DESCRIPTION: Bracket

DRAWING CHANGE: Rev. A

MANUFACTURING DATE: 03/01/29

UNICORP E.O.'S: N/A

BATCH NO.: 18783

SERIAL NO.: N/A

PURCHASE ORDER NO.: 111A

QUANTITY ACCPT. _____ REJ. _____

DATA SHEET NO.: *N/A*

☒ FIRST ARTICLE

□ PERIODIC CONFORMITY

□ FINAL INSPECTION

[illegible]

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Rev. B

Mesured by: RL

Audited by: [Signature]

Approved by: N/A.

Approved by: NA

Dart Aerospace, Ltd

1270 Aberdeen Street

Hawksbury, Ontario

K6A 1K7

Tel: (613) 632-3336 Fax: (613) 632-4443

Supplier Code: _____ Sheet _____ of _____

INSPECTION CHECKLIST

PART NO.: D3178-1

PHY. CHANGE:

DESCRIPTION: Nut plate

DRAWING CHANGE:

MANUFACTURING DATE: 03.01.30

UNICORP E.O.'S: _____

BATCH NO.: 18783

SERIAL NO.: _____

PURCHASE ORDER NO.:

QUANTITY ACCPT. REJ.

DATA SHEET NO.: 1

☒ FIRST ARTICLE

□ PERIODIC CONFORMITY

□ FINAL INSPECTION

[illegible]

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Rev. B

Mesured by: 

Audited by: 

Approved by: N/A